

Date: Thursday, 10/25/2007 10:05:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET HINGE
Job Number	: 35354		
Estimate Number	: 10588		
P.O. Number	:	Part Number	: D22323
This Issue	: 10/25/2007 S.O. No. :	Drawing Number	: D2232 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 33290	Material	:
Written By	:	Due Date	: 10/2/2007 Qty: 50 Um: Each
Checked & Approved By	: <u>10/07/10/25</u>		
Comment	: Est. B 01.06.07 Now laser cut EC Est Rev:C Now on Waterjet 06-10-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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4.0095



Comment: Qty.: 0.0729 sf(s)/Unit Total : 3.6435 sf(s)

304/316 .125 Sheet

Batch: 104934 1B 07-10-30

2.0	WATER JET	FLOW WATER JET
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PFO →

Comment: FLOW WATER JET

1-Cut as per Dwg D2232

Dwg Rev: CProg Rev: C

1B 07-10-30

S8

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 07-10-30



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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counter

Comment: SECOND CHECK

6 2/10/31

754

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1





Deburr

10/27/10/31 54

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2232-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/11/07
 QA: N/C Closed: _____ Date: _____

NCR: <u>35354</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/31	# 2.0	one part SCRAP due to have a small groove cut into the part from the water jet R.C. there was still pressure on the water jet as it moved from part location	 05/10/07	SCRAP and Destroy there are enough parts cut extra to cover the loss of one.	B 07-10- 31	 07/10/31	 05/10/07	 07/10/31

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 35354

Part Number: D22323

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PAT Dural

854

07/11/01 AS

CE

7.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.01

AS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07.11.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

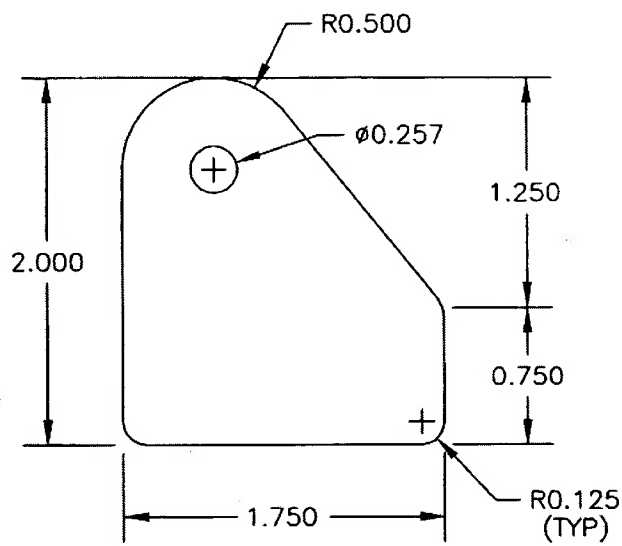
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

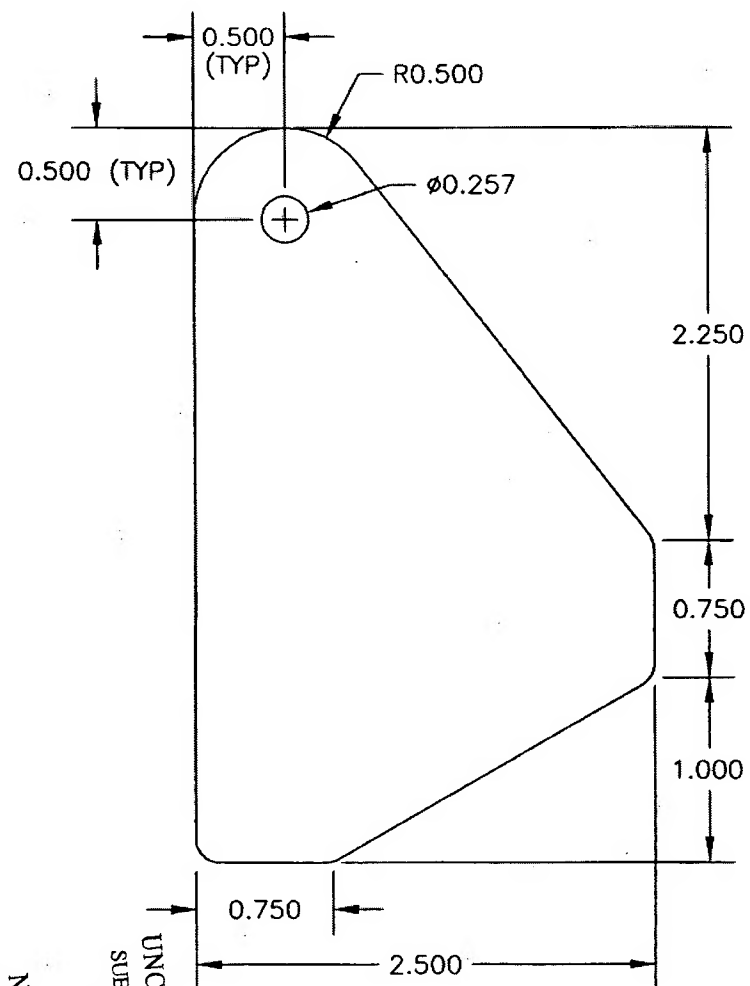


RELEASED
18.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED	APPROVED	DRAWING NO.	D2232	SHEET 1 OF 2
DATE		TITLE	BASKET HINGE	SCALE
98.04.28				1:1
A	94.05.12	NEW ISSUE		
B	96.01.02	ADDED -5 AND -7		
C	98.04.28	0.125 THICK WAS 0.063		



D2232-1



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

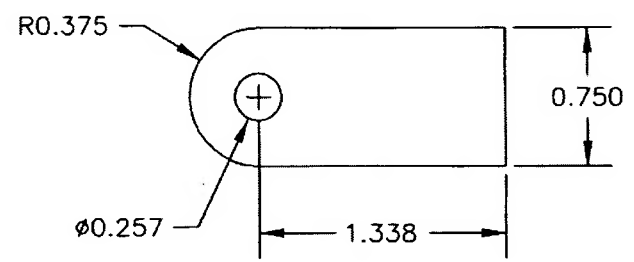
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 35354

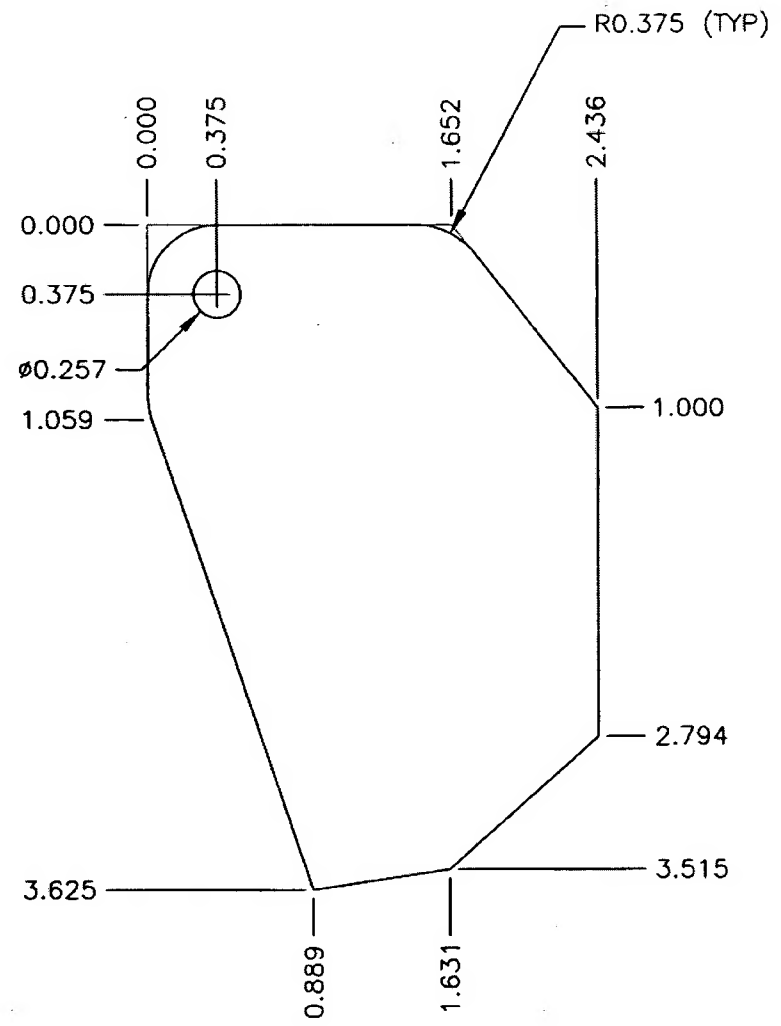


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D2232	SHEET 2 OF 2
98.04.28		TITLE	SCALE
		BASKET HINGE	1:1

RELEASED
48.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

NO. 35354
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DART AEROSPACE LTD